



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

May-10-12 2:35:39 PM

Page 2

## Quality Control

8/12/21

12/06/21

12.06.21

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# Work Order ID 84372

**\*84372\***

Page 3

May-10-12 2:35:39 PM

Item ID: D3643-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Stiffener

Start Date: 10/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 Chemical Conversion Coat per QSI005 4.1 0.00

**\*160\***

HandFinish

Memo

0.00

Hand-Finishing

80 76 12-6-25

170 QC3- Inspect Part Finish 0.00

**\*170\***

QC

Memo

0.00

Quality Control

12-6-25 (8)

180 Identify as per dwg & Stock Location: **ST-244A** 0.00

**\*180\***

Packaging

Memo

0.00

Packaging

8x 12-6-25

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**Work Order ID 84372**

May-10-12 2:35:39 PM

**\*84372\***

Page 4

Item ID: D3643-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Stiffener

Start Date: 10/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12/6/26 JJ

MK 12-06-25

W/O:		WORK ORDER CHANGES					
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# Picklist Print

May-10-12 2:35:43 PM

Page 1

Work Order ID: 84372

\*84372\*

Parent Item: D3643-1

\*D3643-1\*

Parent Item Name: Stiffener

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	178.8312	0.1475	0.621053	1.5		

\*M2024T3S 040\*

2024-T3 .040 sheet

\*\*

812-6-18

Location

Loc Qty

Loc Code

MAT022

178.8311626

117684

21.318421

120196

25.85

120605

64.7627416

121197

66.9

120196

8

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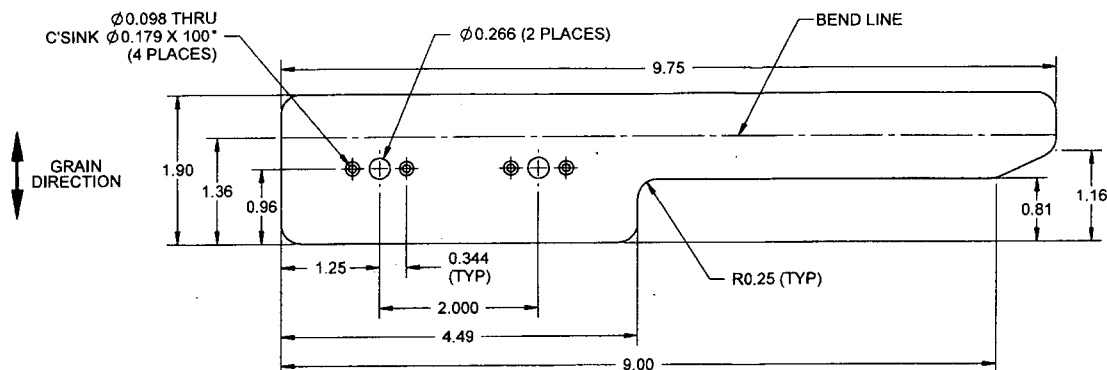
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

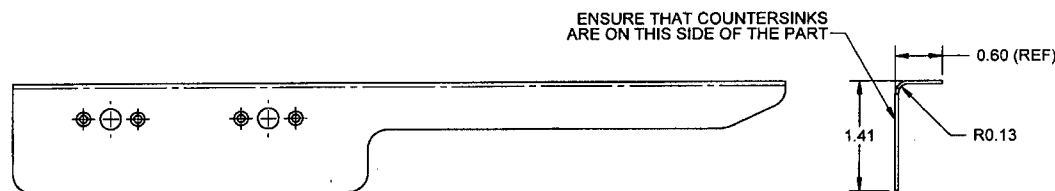
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D3643-1F FLAT PATTERN**  
**(D3643-2F OPPOSITE)**



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)**  
**D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84372 MLJ  
12/05/11

**RELEASED**  
07.09.07

A	NEW ISSUE; REPLACES G10610		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	DT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3643</b>  TITLE <b>STIFFENER</b>		
DRAWN	DT			
CHECKED	DT			REV. A
MFG. APPR.	DT			SHEET 1 OF 1
APPROVED	DT			SCALE
DE APPR.	DT			2:
DATE	07.07.27			
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**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

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